

Date: Monday, 18/06/2007 1:48:32 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUPPED WASHER
 Job Number : 32923
 Estimate Number : 12885
 P.O. Number :
 This Issue : 18/06/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : PURCHASED PARTS
 Previous Run : 32693
 Written By : u
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-05-28 JLM

Part Number : D36281
 Drawing Number : UNDER REVIEW *REV B*
 Project Number : N/A
 Drawing Revision : *HR REV B* *LE 07-08-24*
 Material :
 Due Date : 29/06/2007 Qty: 1,000 Um: Each

Additional Product

POSITIVE RECALL

EFFECTIVE 07-06-18 AUTH uRELEASED u DATE 07-08-24

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING

Comment: Issue P/O: 3997

Email or Ship DXF file to vendor

Laser Cut D3628-1 flat pattern and form as per Dwg D3628

Possible Supplier: GFI

Material release note is required

*C 207/06/18**1000*

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

*EP 07/08/22 1000**2/2/21**500x*

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

QSP 019
*en 27/08/24**X1000**counted*

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

N/A *EP 07/08/24*

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/06/2007 1:48:32 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUPPED WASHER

Job Number: 32923

Part Number: D36281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker on under side of part, then Stock

Location: _____

Handwritten: 8/08/27 (1000)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Handwritten: 1000

Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 8/08/27

Job Completion



Handwritten: 11 8/08/27

POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED *[Signature]* DATE *8/08/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

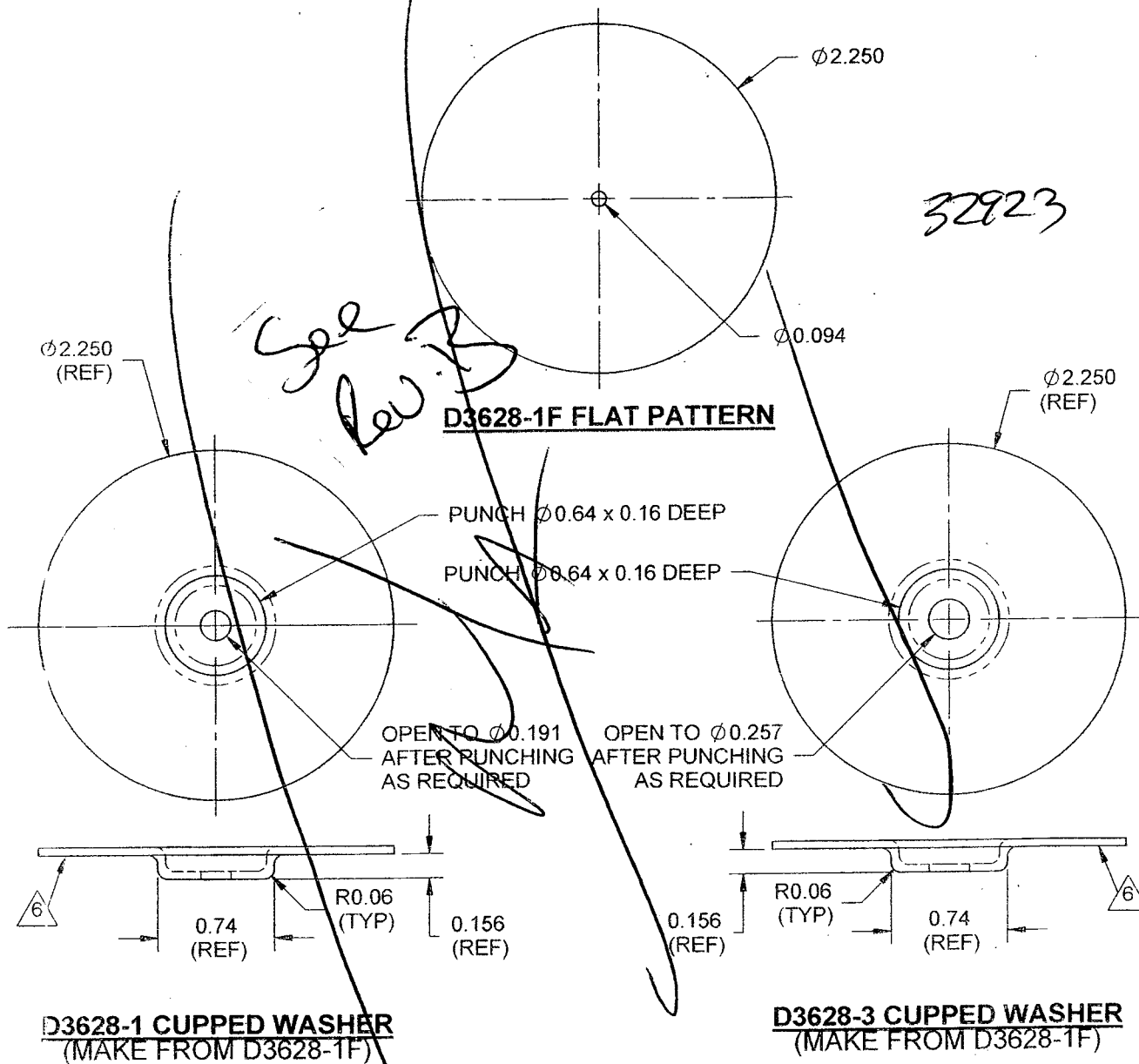
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOT APPROVED

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3628	REV. A SHEET 1 OF 1
DATE 07.06.08	TITLE CUPPED WASHER		SCALE 1:1
REV A	DATE 07.06.08	DESCRIPTION NEW ISSUE	



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK
MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2007/08/17	0371766

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	JO164836	PO00003997	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
1000	D36281 <i>CP 07/08/22</i>	CUPPED WASHER CERTIFICATE OF CONFORMANCE REQ	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Member of / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

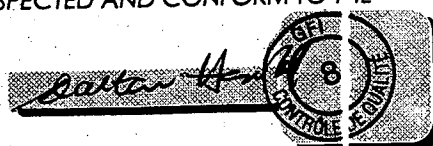
CERTIFICATE NO. 1		OUR JOB NO. J0164836		SHIPPING MEMO 0371766	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
1000 PCS	PO00003997	D36281	A	CUPPED WASHER	A
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
AMS 5513 304 ANN		SIGMA METALS / AK STEEL		H/N # 7361392	

#	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **17 AUGUST 2007**

G.F.I. Q.C. REP.



572-07



Sigma Metals Inc.
45 Jefryn Blvd.
Deer Park, NY 11729
A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

Invoice

DATE INVOICE NO.
 7/23/2007 44E54

POSTED

BILL TO

GFI INC.
 180 AVENUE LABROSSE
 POINT-CLAIRE
 QUE. CANADA
 H9R 1A1

SHIP TO

GFI INC
 180 AVENUE LABROSSE
 POINT-CLAIRE
 QUE. CANADA
 H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0071985	Net 30	ETF	NEW PENN	DEER ARK, NY	57022
ITEM	DESCRIPTION	QTY	RATE	AMOUNT	
SS T304	304A S. SHEET AMS 5513 .050 X 48 X 96 132 LBS MILL. AK STEEL LOT #7361392 PRICED PER PC	2	395.00	790.00	
SKID	SKID CHARGES	1	85.00	35.00	
<p>CERTIFICATE OF COMPLIANCE THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED GREG SALADINO, QC</p>					
ORDER COMPLETE .. TEST REPORTS WITH SHIPMENT WE NOW ACCEPT VISA, MASTERCARD AND AMERICAN EXPRESS				Total	\$875.00



AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 1

Load No. 3218017
SRN No. 8238017

CUSTOMER

SHIP TO

MILL ORDER NO. 271940-0740
PROCESSOR ORDER NO. 01009299

PART NO.
00624

ENGLISH UNITS --PRODUCT-- METRIC UNITS
.0500 NOM. 48.0000 X COIL

SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT
SKD792807	1	7361392	0787628-05	17,330 LBS. 7,861 KG.
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT
1	1			17,330 LBS. 7,861 KG.

L-Ladle Analysis of Hval

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7361392	.022	1.27	.026	.001	.35	18.13	8.07	.33	.033	.37						

SHIPPING DATE: 12/20/2006

REMARKS:

THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.
NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA
SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING
ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.
COILED PRODUCTS CONTAIN NO WELDS
MATERIAL MEETS REQUIREMENTS OF TYPES 304 & 304L FOR REFERENCED SPECIFICATIONS

PRODUCT DESCRIPTION

CR SHT TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE * AMS 5513 H * ASTM A 240 -06 (UNS S30400) * AMS 5511 H * AMS 5516 H *
ASTM A 666 -03 * MILS-5059 D-AMEND-3 * UNS-S30403 9TH EDITION * FMI-304L/304/302 ISSUE 7, 2/13/06 * ASME SA-240 SECTION II PAR
T A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 ED APPLY * UNS-S30400/S30200

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG 1 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front			
0787628-05	T	T	A.S.T.M	56.3	89.4	37.7	B 77	B 77			

QC APPROVED
BY:
DATE: 7-12-07

*** CONTINUED ON NEXT PAGE ***

SLUGS METALS

01/21/2007 13:43 FAX 0312433420



AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 2

Lot No. 3238037
SRN No. 3238037

CUSTOMER

SHIP TO

MILL ORDER NO. 271941-0740
PROCESSOR ORDER NO. 01009299

PART NO.
00624

ENGLISH UNITS --PRODUCT-- METRIC UNITS
.0500 NOM 48.0000 X COIL

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	GRAIN SIZE ASTM E112	BEND 180 IT					
0787628-05	T		ASTM	PASS	8.00	PASS					
0787628-05	F		ASTM	PASS	9.00	PASS					

Σ SIGMA METALS INC.
THESE TEST REPORTS APPLY TO:

P.O. 0071985

S/O 57072

PCS. 2

NET 132 #

FTG

DATE

7-23-07

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT
AS CONTAINED IN THE RECORD OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH ALL STANDARDS UNLESS OTHERWISE NOTED.

AK Steel

000000000 5/20

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK
Steel Corporation. TO AVOID THE POSSIBILITY OF ITS ABUSE ON DELIVERY OF THE REPORT TO A
THIRD PARTY IT MUST BE RECEIVED BY AND UNDER THE NAME OF SAID CONSIGNEE"

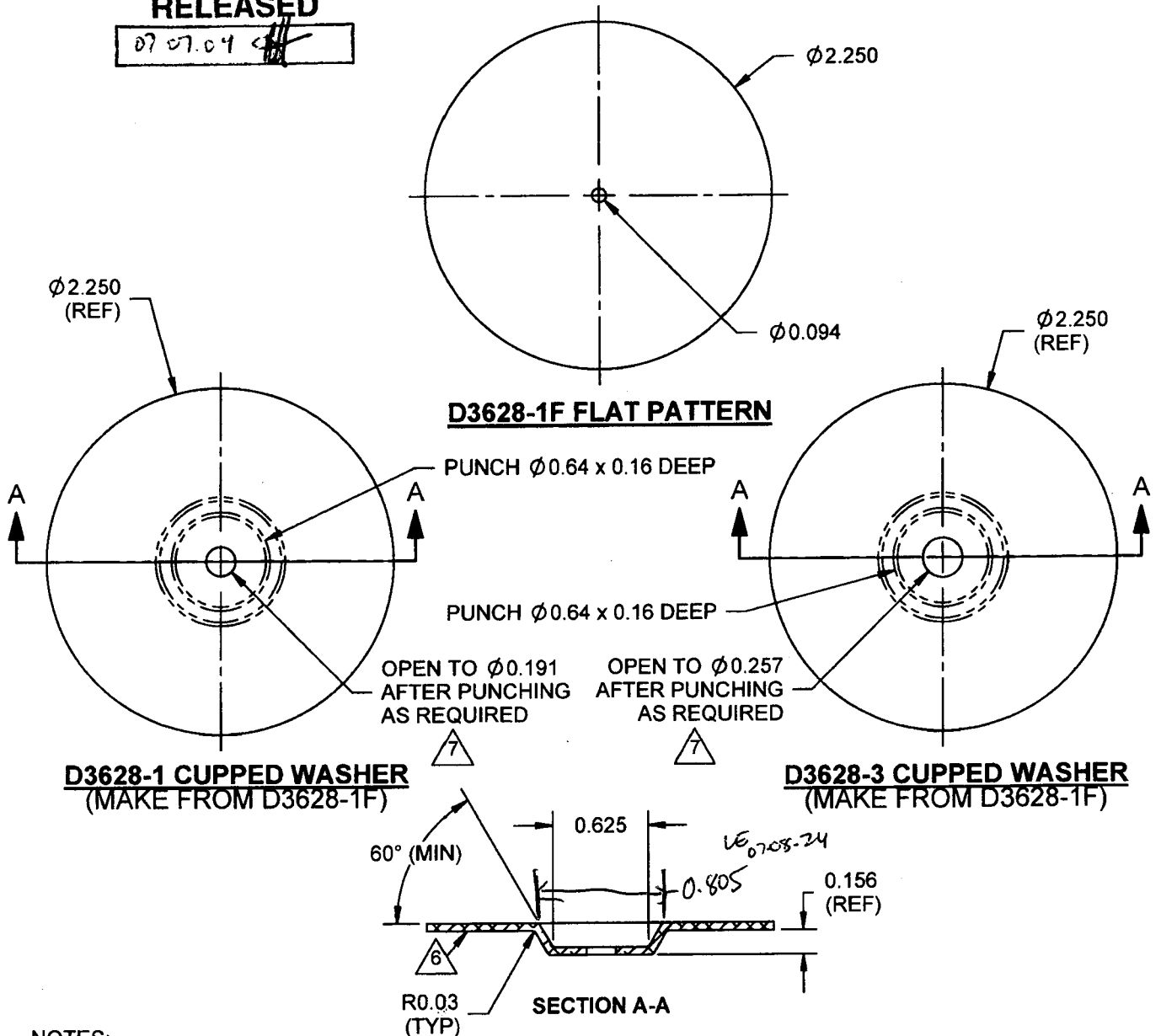
SIGNED

Steve Kayman
APPLICABLE EMPLOYED

DATE 7/21/2009 TIME 12:37 AM

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D3628	REV. B SHEET 1 OF 1
DATE 07.07.09		TITLE CUPPED WASHER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	07.06.08	NEW ISSUE	
B	07.07.09	REMOVE POWDER COAT	

RELEASED07.07.09 **[Signature]****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3628-1/-3" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03

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